

**Work Order ID 69430**

Wednesday, May 11, 2011 9:52:00 AM

Page 1

Item ID: D2512

Accept

Revision ID:

Item Name: Basket Lid 205/350

Start Date: 5/11/2011 Start Qty: 1.00

Required Date: 5/16/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: 1117884 0.00  
Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512  
2-Cut (4) D2236 From D3166-3  
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 --- SAD 11-08-05  
4-Weld as per Dwg D2512 using Welding Jig DT 9436  
Deburr as required  
\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

11-08-09

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

11-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69430**

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

125

Pressure Wash per QS1005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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**Work Order ID 69430**

Wednesday, May 11, 2011 9:52:00 AM

Page 4

Item ID: D2512

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid 205/350

Start Date: 5/11/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/08/11 @

160

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

W/O  
69426

EP 11/08/11 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12

11-08-11  
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, May 11, 2011 9:52:06 AM

Page 1

Work Order ID: 69430

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

## Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24, plug holes prior to powder coating DD verified  
 by:EC IPP Rev:R 10.06.29  
 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	20.0000	2	2			
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Clevis

Location	Loc Qty	Loc Code
WA005	20	
55729	20	

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1		Manufactured	No			100	Each	4.0000	2				
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

Basket Hinge

Location	Loc Qty	Loc Code
WA005	4	
55791	4	

D2327-1		Manufactured	No			100	Each	21.0000	2				
---------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

Spacer Bushing

Location	Loc Qty	Loc Code
WA005	21	
60174	1	
64899	20	

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

10.0000

1

1



Label Plate

Location

Loc Qty

Loc Code

WA

10

69262

10

B71087 → ①

D2581

Manufactured No

100

Each

38.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

38

68964

38

B70766 → ②

D3166-3

Manufactured No

100

Each

0.8625

1

1



Basket Hoop

Location

Loc Qty

Loc Code

WA007

0.86250527

64928

0.86250527

B70189

①

M304EX0.75-16F

Purchased No

100

sf

518.0152

18

18.94737



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA

518.0152

115012

114

117197

182.3016

117455

221.7136

M118450 → 18.94737

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Page 3

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

1,259.992

43.5804

45.87411



SAD 11-08-06

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT018

1000

117598

1000

WA007

259.9928906

116267

162.707172

116763

97.2857186

5.8741

M118181

40.00

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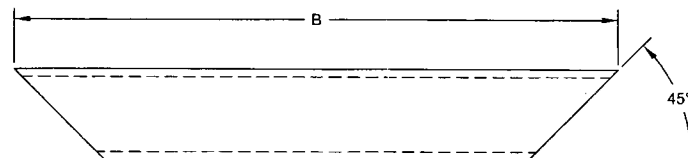
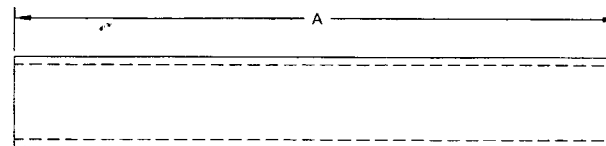
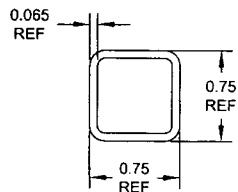
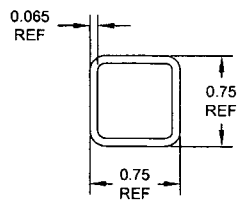
**NOTE:** Date & initial all entries

# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69430  
*P/1105-4*

**RELEASED**  
*08-08-21/11*



**E**

## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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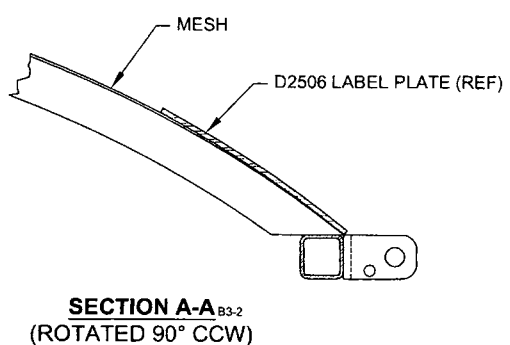
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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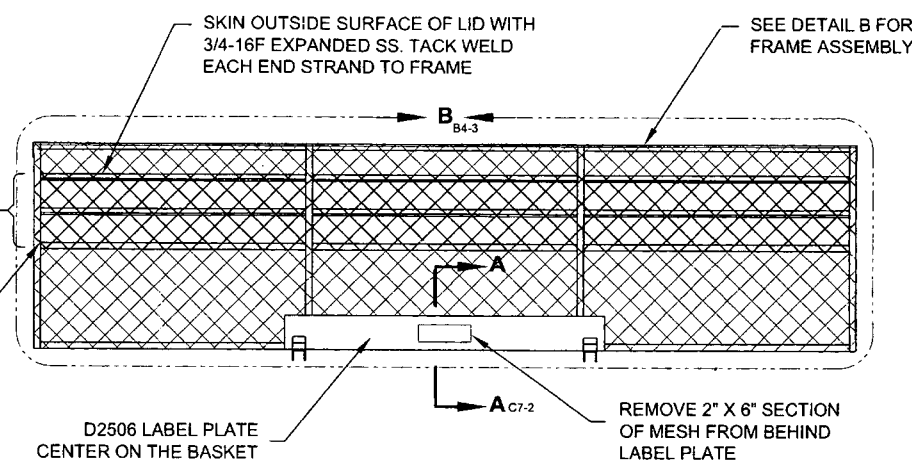
**NOTE:** Date & initial all entries



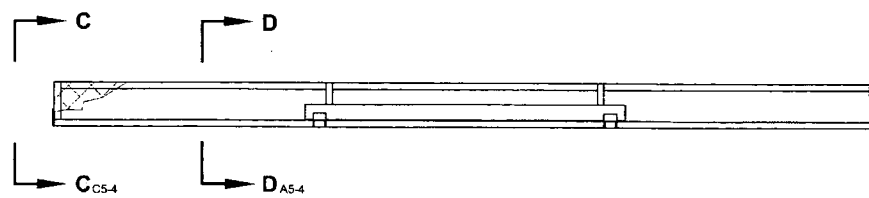
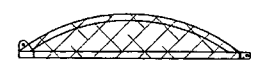


FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



*u609430*



- D2512 BASKET LID ASSEMBLY NOTES:**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
  - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: N/A
  - 7) IDENTIFICATION: NONE
  - 8) WEIGHT: N/A
  - 9) WELD PER DART QSI 004

**RELEASED**  
05 05-21/11

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

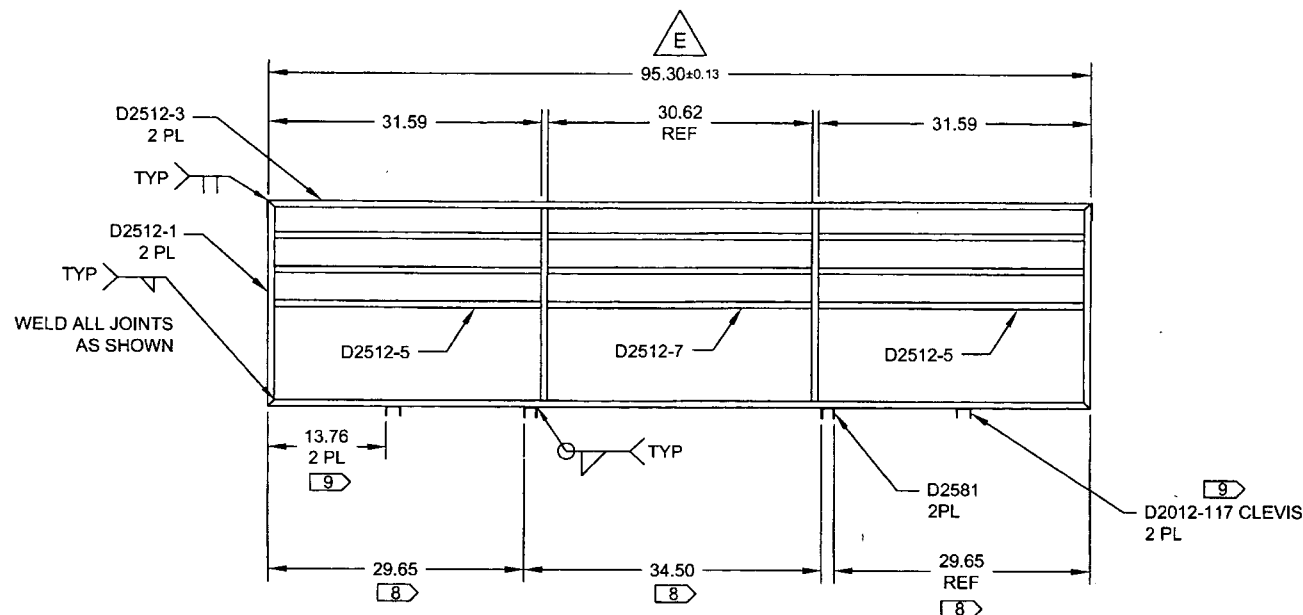
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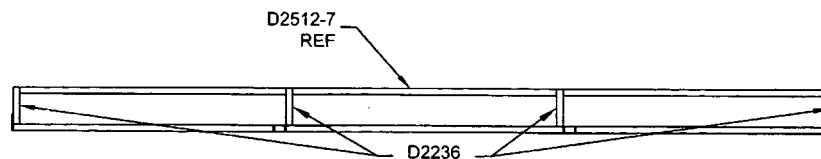
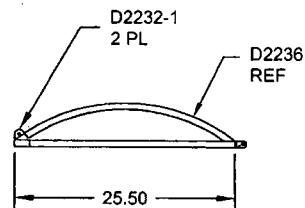
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



*u/o 69430*

**RELEASED**  
08 06 17

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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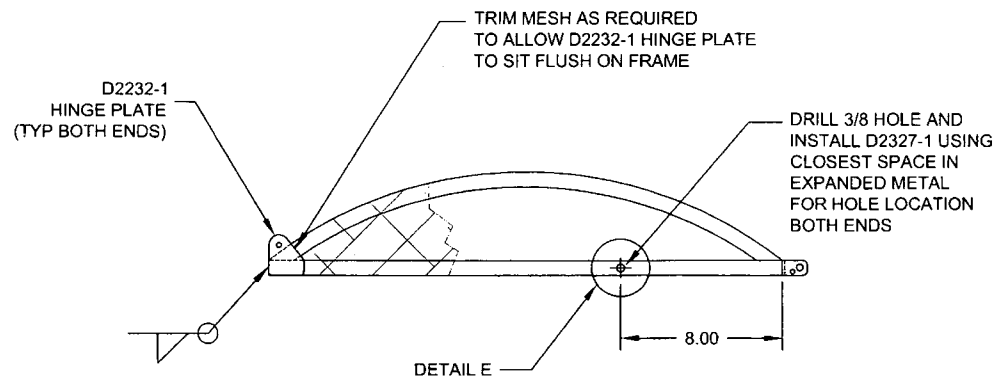
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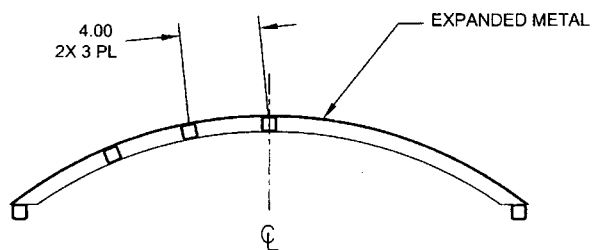
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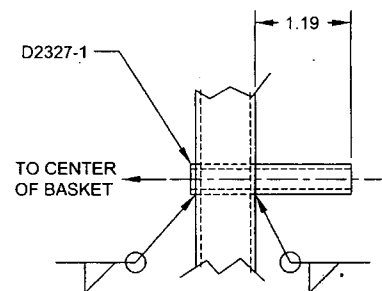
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**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

**RELEASED**  
08-06-21/17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries